

Work Order ID 70595



Page 1

Monday, June 13, 2011 11:25:27 AM

Item ID: D3443-7

Accepted



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 6/10/2011 **Start Qty:** 4.00



Cust Item ID

Required Date: 6/22/2011 **Req'd Qty:** 4.00



Customer

Reference:

Approvals: Process Plan:

Date: 10/11/12

Tooling

Date:

Run Start



OC:

Date:

SPC (Y/N)

Date: _____

Stop



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70595

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Page 2

Item ID: D3443-7

Accept



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Mill Conv

Conventional Milling Machine

Operation
Description

CONVENTIONAL MILLING MACHINE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11/07/04

5

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

11/07/04

5

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 11/07/04

5

0

0.00

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Page 3

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Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

160



Packaging

Packaging

Identify as per dwg & Stock Location: W/ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

0.00

EL 11-7-6- 15

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/16/10

UNF 11-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:25:35 AM

Page 1

Work Order ID: 70595



Parent Item: D3443-7



Parent Item Name: Tubing

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: A□05.11.14□New issue□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	29.4400	0.75	3157895		EP 31/06/29	

304 ss round tube .750 x .120w



Location	Loc Qty	Loc Code
MAT017	29.44	
114706	29.44	

3157895

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

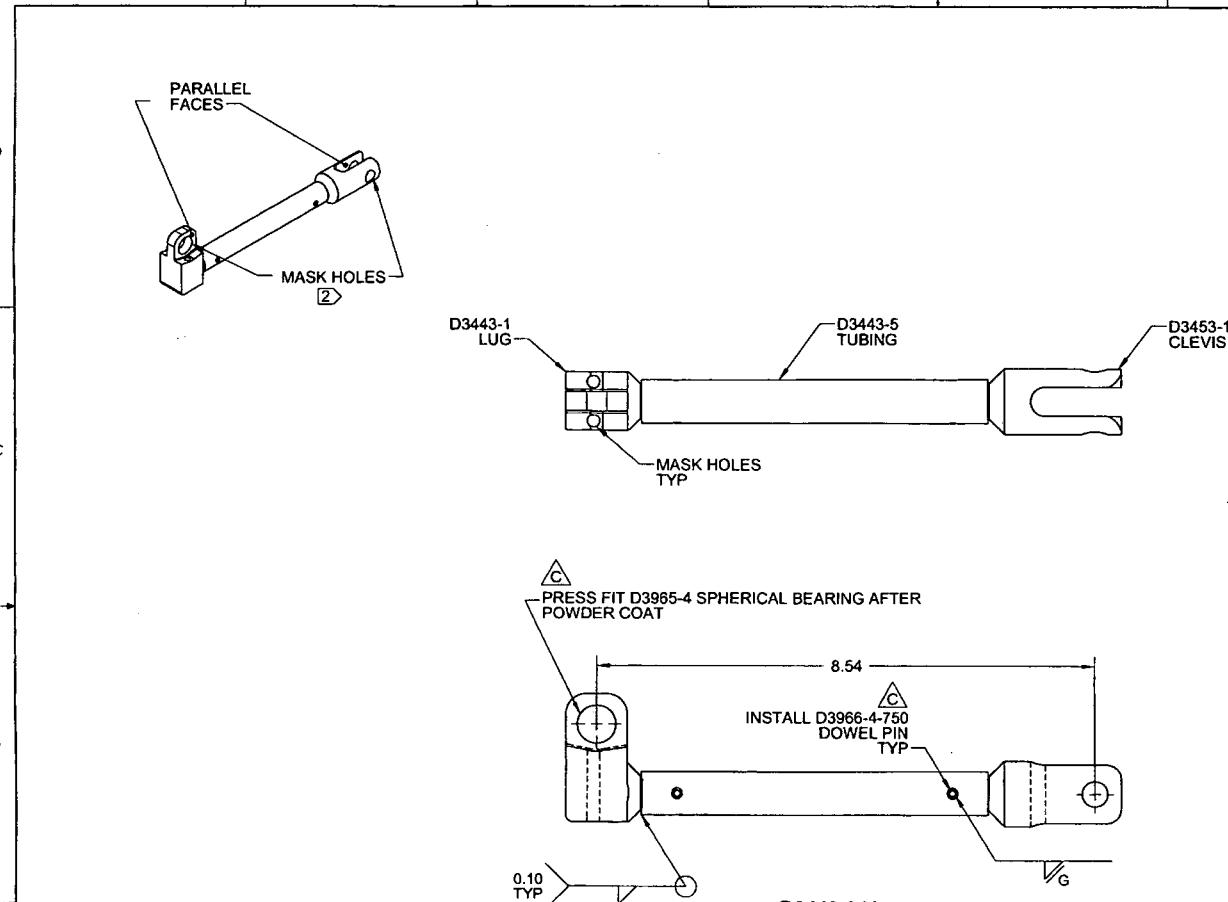
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.33 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70595
PL11-06-03

RELEASED
09/06/03

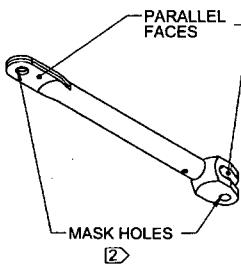
C	DRAWING UPDATED TO CURRENT STANDARDS, REVISED NOTE #2 (ZN AB-1, AB-2): 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.561 WAS 0.451 (ZN C1-3); R0.219 WAS 0.050 (ZN C4-3); D3965-4 WAS SPAENAUER P/N (ZN C6-1, B5-2); D3966-4-750 WAS McMaster-Carr P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>99</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>WV</u>	D3443	SHEET 1 OF 4
APPROVED	<u>WV</u>	TITLE	SCALE
DE APPR.	<u>WV</u>	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

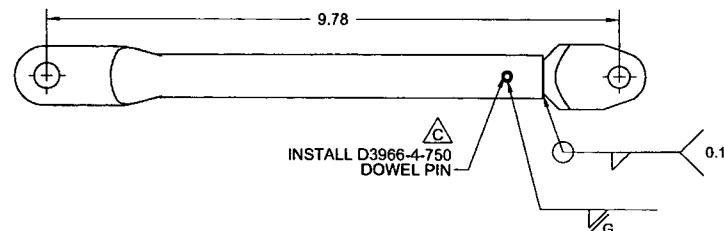
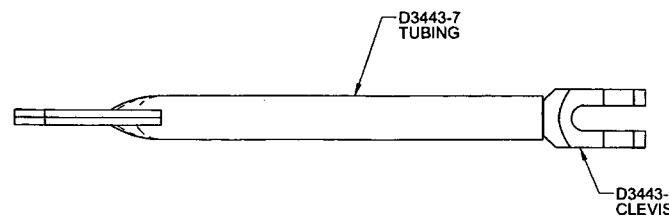
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



D3443-043

W070585

RELEASED
09/05/2014

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.97 lbs
 - 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>LP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>S. J. S.</i>	D3443	SHEET 2 OF 4
APPROVED	<i>S. J. S.</i>	TITLE	
DE APPR.	<i>S. J. S.</i>	SCALE	
DATE	09.06.25	STRUT WELDMENT ASSEMBLY NTS	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

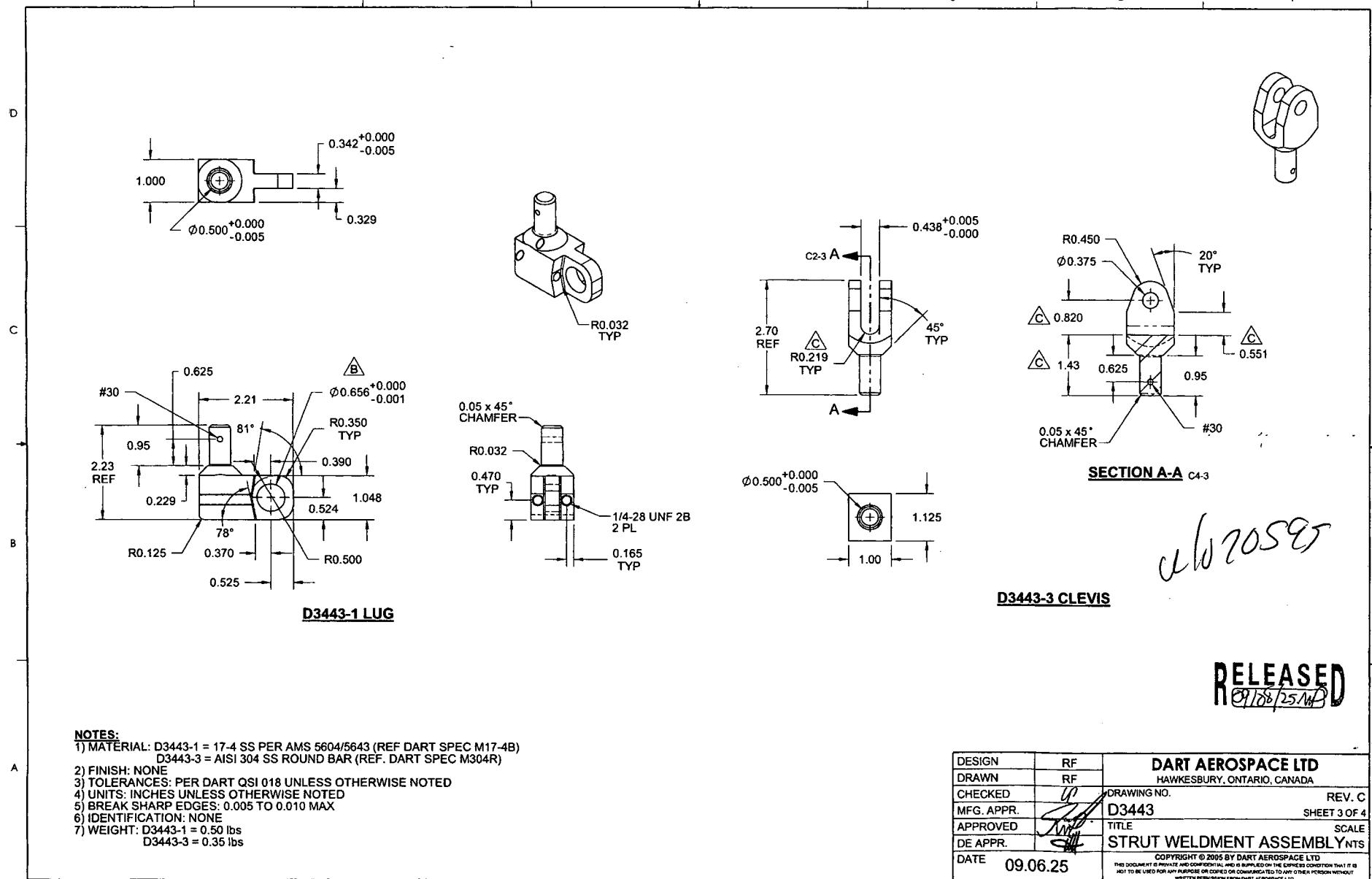
5

4

3

2

1

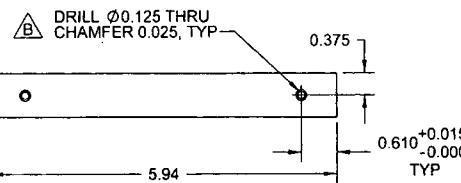


W/O:		WORK ORDER CHANGES					
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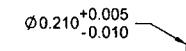
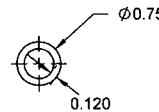
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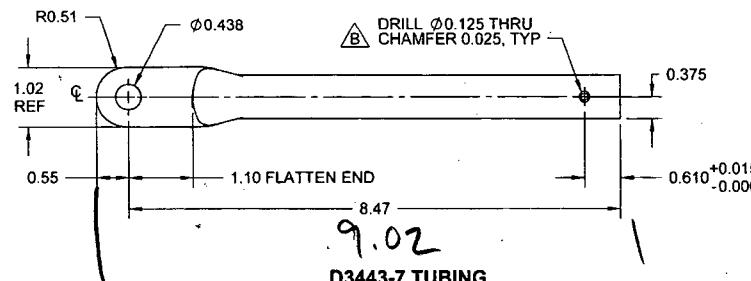
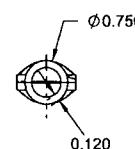
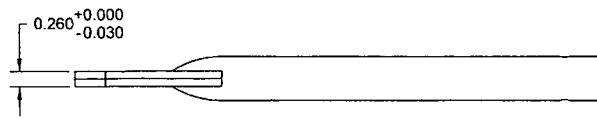
NOTE: Date & initial all entries



D3443-5 TUBING



D3443-9 PIN



D3443-7 TUBING

D3443-5/-7 NOTES:
 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: D3443-5 = 0.41 lbs
 D3443-7 = 0.62 lbs

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

10/10/09

RELEASED
01/08/29 M

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	01	DRAWING NO.	REV. C
MFG. APPR.	W	D3443	SHEET 4 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	W	STRUT WELDMENT ASSEMBLY	NTS
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70595
Description: Tubing	Part Number:	3443-7
Inspection Dwg: 3443 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	
Date:	11/07/04	Date:	11/07/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	